

Date: Friday, 22/05/2009 8:58:47 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 STEP END PLATE
Job Number : 48110	
Estimate Number : 11021	
P.O. Number :	Part Number : D2734
This Issue : 22/05/2009 S.O. No. :	Drawing Number : D2734 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 43535	Material :
Written By :	Due Date : 28/05/2009 Qty: 100 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est:D 01.06.08 Removed Deburr EC Est Rev:E 07-12-18 RevC as per dwg ECN1048 DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S063	5052-H32 .063 Sheet
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**Comment:** Qty.: 0.0656 sf(s)/Unit Total : 6.5625 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.063" thick

(M5052H32S.063)

Batch: 103755 B 96-10

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D 2734

Dwg Rev: CProg Rev: C

B 96-10

2-Deburr if necessary

B 96-10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B 96-10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Form as per drawing D2734

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 09/06/15 (cont'd) (+116)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: U1A

PE 09-06-17 116

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/17

Job Completion



RF 09-06-17

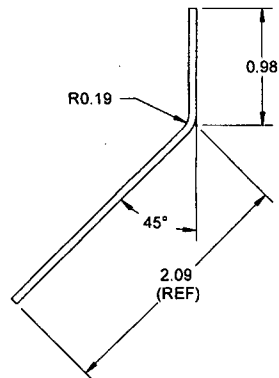
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

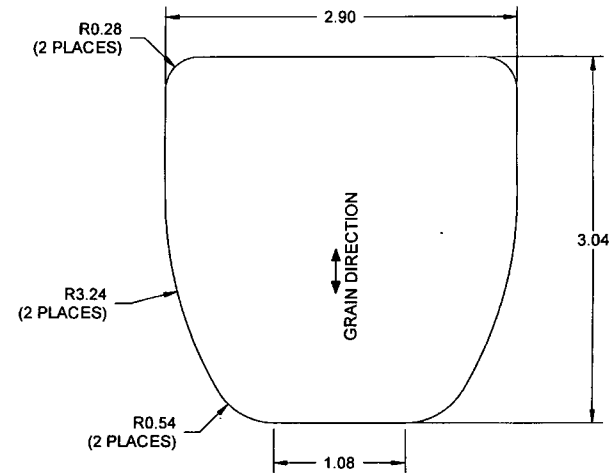
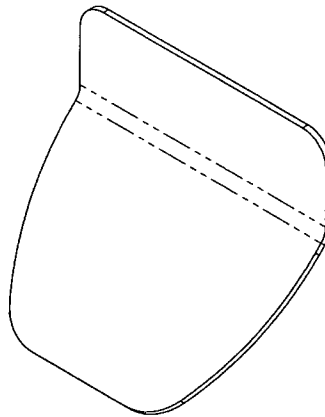
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2734 END PLATE



D2734 FLAT PATTERN

RELEASED
07.12.16

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T6) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs

NO. 18110
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

C	ADD GRAIN DIRECTION NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.20
B	0.976 WAS 1.016, 2.097 WAS 2.137	KE	98.10.05
A	NEW ISSUE	KE	97.12.10
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KE		
CHECKED	KE	DRAWING NO. D2734	REV. C
MFG. APPR.	KE	TITLE END PLATE	SHEET 1 OF 1
APPROVED	KE	SCALE 1:1	
DE APPR.	KE	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	07.11.20		